

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009530**Date Inspected:** 09-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Ging , Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #10

This QA Inspector randomly observed the following work in progress.

NORTH TOWER LIFT # 3

Flux Cored Arc welding process of weld joint 32 located on PCMK NSTL3-3K/K. Welder is identified as 053870 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair.

Flux Cored Arc welding process of weld joint 34 located on PCMK NSTL3-3K/K. Welder is identified as 040343 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair.

SOUTH TOWER LIFT #4

Flux Cored Arc welding process of weld joint 142 located on PCMK SSTL4-1C/K. Welder is identified as 057180 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

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Flux Cored Arc welding process of weld joint 143 located on PCMK SSTL4-1C/K. Welder is identified as 057266 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 138 located on PCMK SSTL4-1G/L. Welder is identified as 053116 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 139 located on PCMK SSTL4-1G/L. Welder is identified as 054069 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

BAY#11

This QA Inspector randomly observed the following work in progress.

Submerged Arc welding process of weld joint 1A and 2A located on PCMK WSD1-STSA3-2-89-1. Welder is identified as 040699 ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-1.

BAY#14

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 10CW

Flux Cored Arc welding process of weld joint 009 located on PCMK SEG063A. Welder is identified as 202122 ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

Shielded Metal Arc welding process of weld joint 020 located on PCMK SEG063A. Welder is identified as 051348 ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for

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your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer